Page 1

Monday, September 20, 2010 10:14:50 AM Item ID: D3684-043 Accept Setup Start **Revision ID:** Stop **Item Name:** MOUNT ASSEMBLY Start Qty: 1.00 **Start Date:** 9/20/2010 **Cust Item ID:** Req'd Qty: 1.00 **Required Date:** 10/1/2010 **Customer:** Reference: Start Run Process Plan: Date: (0-9-20 Tooling: Approvals: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation **Tool ID** Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D3684 Rev D 100 Pick Kit 0.00 10 (09/21 Packaging 0.00 Memo Packaging 110 0.00 Small Fab Small Fab 0.00 Memo Small Fab 1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivelent Sp 10/09/21 on thread and assemble as per dwg D3684 \(\preceq\)2-Assemble D3684-049 & D3687-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684 *** Ensure holes for AN3C Bolts are free o

QC5- Inspect part completeness to step on W/O

Memo

(Anitoric on theress of Klow/ D 3688-5)

120

Quality Control

W/O:			V	ORK ORDER CHAN	GES						
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:		tegory:	NCR: Yes	No DQA	۸:	Date: _			
							sed: Date:				
NCR:		W	ORK OR	DER NON-CONFORM	IANCE (NCI	₹)			i		
DATE	STEP	Description of NC			ection B	Verific		Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector		
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Work Order ID 62168

Page 2

Monday, September 20, 2010 10:14:50 AM

Item ID:

D3684-043

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Required Date: 10/1/2010

MOUNT ASSEMBLY

Start Date:

9/20/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Date:

Tooling: SPC (Y/N):

Date:

Date:

Run Start

Qty

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 1390

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/09/23 tg) Mr 10-9-23

W/O:		WORK ORDER CHANGES											
DATE STEP		PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector				
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Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	Yes No DQA: Date:							
	Re	esolution:	Dispositi	on:	_ QA: N/C C	osed:		Date: _					
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NCF	₹)							
DATE	STEP	Description of NC			ion B	Verifi	Verification	Approval	Approval				
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign a Date		ion C	Chief Eng	QC Inspector				
								~					

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Picklist Print

Monday, September 20, 2010 10:14:49 AM

Work Order ID: 62168

Parent Item:

D3684-043

Parent Item Name: MOUNT ASSEMBLY



Start Date: 9/20/2010

Required Date: 10/1/2010

Start Oty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue 08-02-12 DD verified by:LL

IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC

REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC

IDD Day: C Added sealant note as ner Rev C 00-01-20 II M Verified By:DD

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	86.0000	4	4 33	10/0	16/21	
				Location		Loc (<u>Oty</u>	Loc Code					
				ST351			86				_		

IPP

			Location	Loc	: Qty	Loc Code				
			ST351		86					
			112314	* 6	8					
			114761		11			-4		
			115392		47					
			115594		20		_			
D3684-047	Manufactured	No		110	Each B	62164	 	1	1 /	
					D	00.4		513	10/09/21	
FWD LEG ASS'Y										
D3684-049	Manufactured	No		110	Each	2152 0.0000	1	1	. /	
					Blo	2162		SB	10/09/21	
AFT LEG ASS'Y							1 (88) 168)		10 (01/0)	
D3687-1	Manufactured	No		110	Each	3.0000	1	1		
	Manufactured							•	1 1 . /	
								<i>≥</i> 6_	10/09/21	

<u>_ocation</u>	Loc Qty	Loc Code	
ST075	3		·····
61971	3		

MOUNT

W/O:		WORK ORDER CHANGES										
DATE STEP		PRO	OCEDURE CH	В	у	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: `	Yes N	lo DQA :	· · · · · · · · · · · · · · · · · · ·				
		esolution:							***			
NCR:			WORK OR	DER NON-CONFORM	IANCE (I	NCR)	,					
DATE	STEP	Description of NC	Initial	Corrective Action Section B Action Description		ign &	Verification		Approval			
		Section A	Chief Eng	Chief Eng	3	Date	Section C	Chief Eng	QC Inspector			
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Monday, September 20, 2010 10:14:49 AM

Work Order ID: 62168

Parent Item:

D3684-043

Parent Item Name: MOUNT ASSEMBLY



Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Oty: 1.00

D3692-1

SPACER

Manufactured

Purchased

110

Each

349.0000

(0/09/21

Location ST082

No

51467

Loc Qty 349 349

Each

Loc Code

2,643.000

MS21043-3

Location	Loc Oty					
FG	76					
103691	76					
ST301	2567					
109147	4					
111383	46					
112314	2517					

110

Loc Code

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date Q	ty Approval Chief Eng /	Approval QC Inspector				
								Prod Mgr					
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]				
Part No	:	PAR #:	Fault Cat	egory:	NCR	: Yes N	o DQA: _	Date: _					
	R	esolution:	Dispositi	on:	QA:	N/C Clos	sed:	Date: _					
NCR:		\	VORK ORD	DER NON-CONFORM	IANCE	(NCR)							
245	CTED	Description of NC Corrective Action Section					Verification	on Approval	Approval				
DATE	SIEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		QC Inspector				
٠													

ITEM PART NUMBER DESCRIPTION 1 D3684-043 MOUNT ASSEMBLY D3687-1 MOUNT 3 D3684-047 FWD LEG ASSY D3684-049 AFT LEG ASSY 5 8 D3692-1 SPACER AN3C-12A BOLT MS21043-3 NUT

AN3C-12A BOLT D3692-1 SPACER, 2X MS21043-3 NUT 2 PL-7 -D3687-1 MOUNT -AN3C-12A BOLT D3692-1 SPACER, 2X MS21043-3 NUT 2 PL D3684-047 FWD LEG ASSEMBLY -D3684-049 AFT LEG ASSEMBLY 4 / 19.40 REF 17.15 REF 4 1 19.85 REF

D3684-043 MOUNT ASSEMBLY

NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED
3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

8

4) DIMENSIONS SHOWN ARE WHEN DISSON 17-5 & DISSON 17-1 STUDY ARE TOLET THIS DISCUSSION STORY ARE WHEN DISSON 17-5 & DISSON 17-1 STUDY ARE TOLET THIS DISCUSSION OF THE DISSON 17-5 & DIS

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DESIGN RF		DART AEROSPACE LTD					
DRAWN	RF.	HAWKESBURY, ONTARIO, CAI	NADA				
CHECKED	-	DRAWING NO.	REV. D				
MFG. APPR.	Vidl	D3684	SHEET 2 OF 5				
APPROVED	11/	TITLE	SCALE				
DE APPR.	#	TRIPOD MOUNT ASSY	NTS				
DATE 10.0	3.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINATE AND COMPONITAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMANDETED TO ANY FORM PERSON IN INOUT WHITTHE PREMISSION FROM DATE ARROPACE LTD					

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			· · · · · · · · · · · · · · · · · · ·										
Part No: PAR #:		PAR #:	Fault Categ	jory:	_ NCF	R: Yes N	o DQA :	Date: _	_ Date:				
Resolution:			Disposition):	QA:	N/C Clos	sed:	d: Date:					
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)							
DATE	STED	Description of NC	Corrective Action Section B Initial Action Description				Verification	Approval	Approval				
DATE	SIEF	STEP Section A		Action Description Chief Eng				Chief Eng	QC Inspector				
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